

# Work Order ID 80525

Wednesday, February 22, 2012 1:38

Item ID: D4131-043  
Revision ID:  
Item Name: Doubler Assembly  
Start Date: 2/22/2012 Start  
Required Date: 2/22/2012 Req  
Reference:

Approvals: Process Plan:  
QC:

Sequence ID/  
Work Center ID  
130  
\*130\*  
Small Fab  
Small Fab

150  
\*150\*  
QC  
Quality Control

160  
\*160\*  
HandFinish  
Hand Finishing

# Work Order ID 80525

Wednesday, February 22, 2012 1:38:33 PM

\*80525\*

Page 1

Item ID: D4131-043 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Doubler Assembly  
Start Date: 2/22/2012 Start Qty: 6.00 \*6\* Cust Item ID:  
Required Date: 2/22/2012 Req'd Qty: 6.00 \*6\* Customer:  
Reference:

Approvals: Process Plan: ✓ Date: 12-02-27 Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start \*NR1\*  
Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4131	B								
100	FLOW WATER JET	0.00							
*100*	Waterjet	0.00							
FLOW CNC Waterjet	Memo								
6061-063	1-Cut D4131-7 as per Dwg								
	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2-Deburr as required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
*110*		0.00							
QC	Memo								
Quality Control									
120	QC8- Inspect parts - second check	0.00							
*120*		0.00							
QC	Memo								
Quality Control									

W 12.02.27 (76)

W 12.02.27 (76)

(76)

Schultz

Dart Aerospace Ltd

W/O:		
DATE	STEP	

Part No: \_\_\_\_\_

Resolution: \_\_\_\_\_

NCR:		
DATE	STEP	De

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approve

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QANCRWO RevE



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 80525****\*80525\***

Page 4

Wednesday, February 22, 2012 1:38:33 PM

Item ID: D4131-043 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Doubler Assembly  
Start Date: 2/22/2012 Start Qty: 6.00 **\*6\*** Cust Item ID:  
Required Date: 2/22/2012 Req'd Qty: 6.00 **\*6\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>ST 132</u>	0.00							
<b>*180*</b>									
Packaging	Memo	0.00							(7x) Sp 12-03-02
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>									
QC	Memo	0.00							MCJ 12/03/02
Quality Control									

Q12-03-2  
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, February 22, 2012 1:38:38 PM

Page 1

Work Order ID: 80525

**\*80525\***

Parent Item: D4131-043

**\*D4131-043\***

Parent Item Name: Doubler Assembly

Start Date: 2/22/2012

Required Date: 2/22/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.10.06 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	190.0096	0.1807	1.141263			
<b>*M6061T6S 063*</b>									<b>**</b>			12-02-27	
6061-T6 .063 Sheet													

Location	Loc Qty	Loc Code
MAT021	190.0095684	
113608	0	
116308	11.4555684	
117285	72.414	
119331	49.2	
119802	22.94	
120218	34	

1.0842

MS20426AD3-3

Purchased

No

165 Each

2,775.000

8

48

**\*MS20426AD3-3\***

Rivet

**\*\***

Location	Loc Qty	Loc Code
ST316	2775	
119109	2272	
19099	503	

56

MS21069L3

Purchased

No

165 Each

301.0000

4

24

**\*MS21069L 3\***

ANCHOR NUT

**\*\***

Location	Loc Qty	Loc Code
ST302	301	
103447	1	
115708	4	
119108	96	
120362	200	

28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	80525.
<b>Description: Plate</b>		<b>Part Number:</b>	D4131-7
<b>Inspection Dwg: D4131 Rev: A</b>		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.102	✓		vern	HB-02
Ø0.191	+0.005/-0.001	0.192	✓		vern	" "
0.405	+/-0.010	0.407	✓		vern	" "
4.600	+/-0.010	4.609	✓		vern	" "
3.64	+/-0.030	3.654	✓		vern	" "
4.81	+/-0.030	4.816	✓		vern	" "
0.59	+/-0.030	0.596	✓		vern	" "
4.10	+/-0.030	4.10	✓		vern	" "
5.41	+/-0.030	5.413	✓		vern	" "
0.66	+/-0.030	0.662	✓		vern	" "
0.405	+/-0.010	0.409	✓		vern	" "
4.000	+/-0.010	4.007	✓		vern	" "
0.063	+/-0.010	0.063	✓		vern	" "

<b>Measured by:</b>	<i>[Signature]</i>	<b>Audited by:</b>	<i>[Signature]</i>	<b>Preliminary Approval:</b>	
<b>Date:</b>	12-02-27	<b>Date:</b>	12/02/29	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	10.10.25	New Issue	KJ <i>[Signature]</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

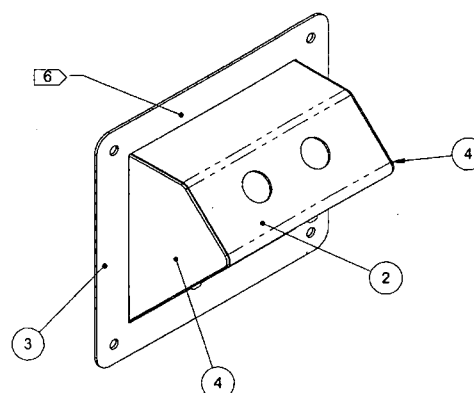
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4131-041	MANIFOLD ASSEMBLY
2	1	D4131-045	BASE ASSEMBLY
3	1	D4131-1	FRONT PLATE
4	2	D4131-5	SIDE PLATE



**D4131-041 MANIFOLD ASSEMBLY**

**RESIDENCE ONLY**  
**RETURN TO**  
**ENGINEERING**  
**UNCONTROLLED COPY**  
**SUBJECT TO AMENDMENT**  
**WITHOUT NOTICE**  
**WORK ORDER**  
**NO. 10525**

*R12-03-2*

**RELEASED**  
 2011-09-21  
*WMD*

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.66 lbs

B	D4131-045 WAS D4131-3 (ZN D3-1); ADD 4131-045 (ZN B4-3); ADD 0.098 (ZN B4-7); ADD 4131-9 (ZN B5-10)	RF	11.07.27
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	<i>MP</i>		
MFG. APPR.	<i>DS</i>		
APPROVED	<i>MP</i>		
DE APPR.	<i>MP</i>		
DATE	11.07.27		

**DART AEROSPACE USA, INC.**

KENT, WA

DRAWING NO. REV. B

D4131 SHEET 1 OF 10

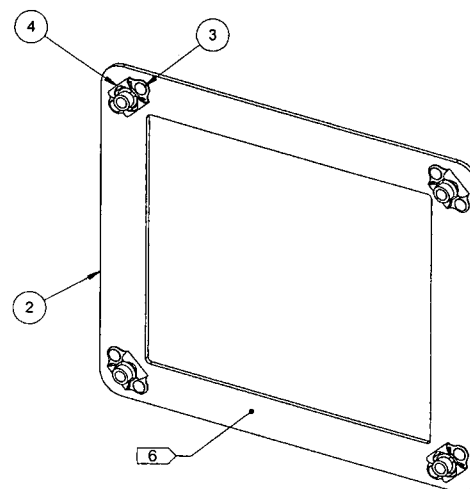
TITLE SCALE

MANIFOLD ASSEMBLY NTS

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ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4131-043	DOUBLER ASSEMBLY
2	1	D4131-7	DOUBLER
3	8	MS20426AD3-3	RIVET
4	4	MS21069L3	NUT PLATE



REFERENCE ONLY

D4131-043 DOUBLER ASSEMBLY

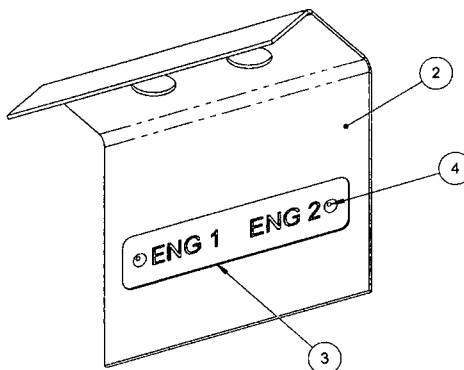
RELEASED  
2011-09-21

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.	DS	D4131	SHEET 2 OF 10
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	MANIFOLD ASSEMBLY	NTS
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ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D4131-045	BASE ASSEMBLY
2	1	D4131-3	BASE
3	1	D4131-9	LABEL PLATE
4	2	MS20615-3M3	RIVET



**D4131-045 BASE ASSEMBLY**



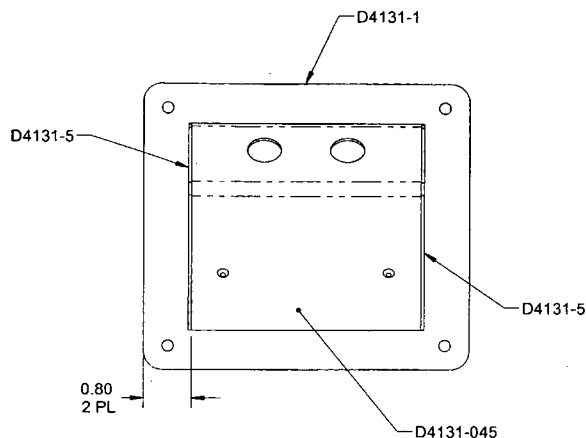
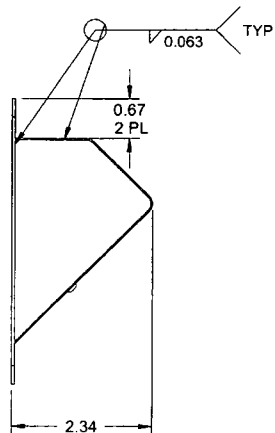
REFERENCE VIEW

**RELEASED**  
2011-09-21

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.35 lbs

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	<i>MP</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>MS</i>	<b>D4131</b>	SHEET 3 OF 10
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	<b>MANIFOLD ASSEMBLY</b>	NTS
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REFERENCE ONLY

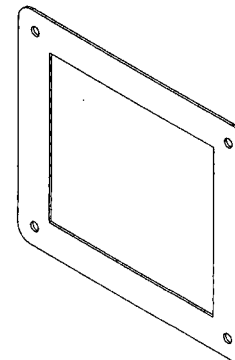
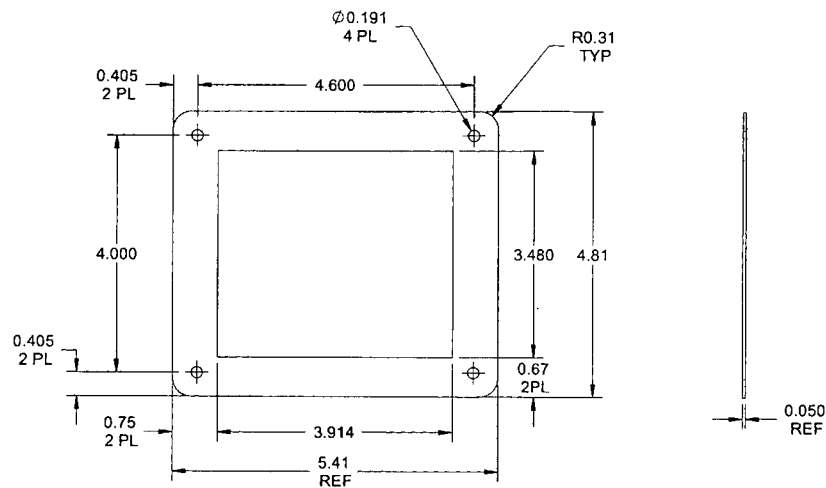
**D4131-041 MANIFOLD ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.66 lbs
- 8) WELD PER DART QSI 004

**RELEASED**  
2011-09-21  
AM

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	MP	DRAWING NO. D4131	REV. B
MFG. APPR.	MP	SHEET 4 OF 10	
APPROVED	MP	TITLE MANIFOLD ASSEMBLY	SCALE NTS
DE APPR.	MP	DATE 11.07.27	
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REFERENCE ONLY

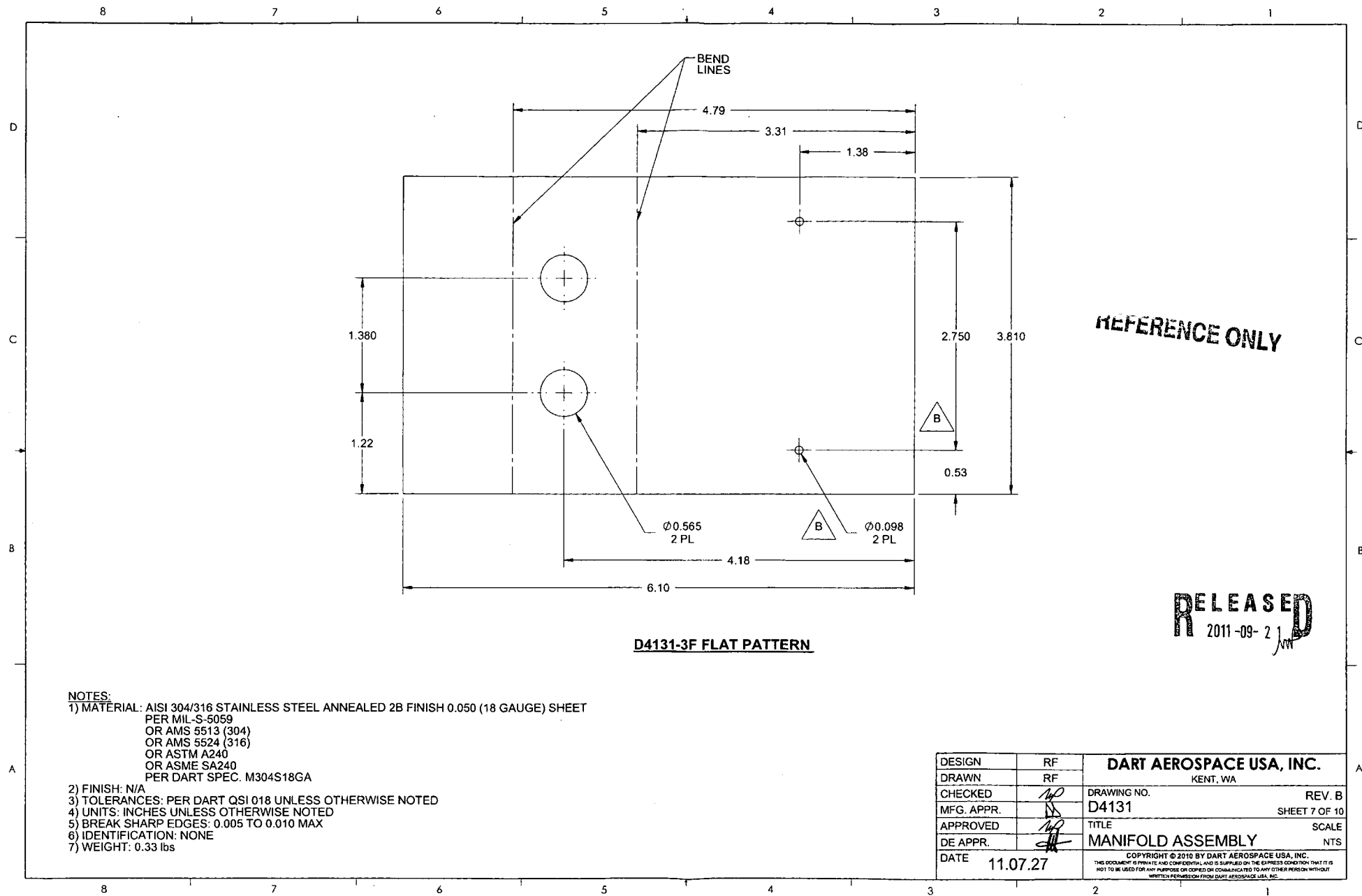
# **D4131-1 FRONT PLATE**

**RELEASED**  
2011-09-21  
JW

## **NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET  
PER MIL-S-5059  
OR AMS 5513 (304)  
OR AMS 5524 (316)  
OR ASTM A240  
OR ASME SA240  
PER DART SPEC. M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.18 lbs

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D4131</b>	SHEET 5 OF 10
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>MANIFOLD ASSEMBLY</b>	NTS
DATE	11.07.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



**D4131-3F FLAT PATTERN**

**NOTES:**

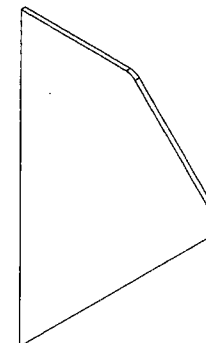
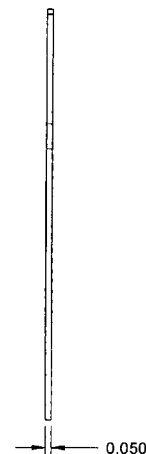
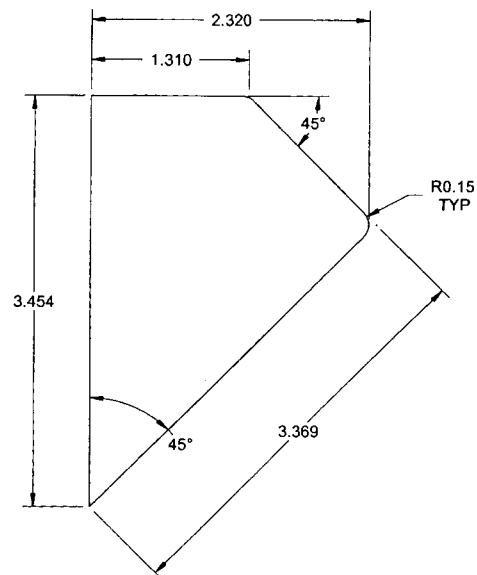
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET  
PER MIL-S-5059  
OR AMS 5513 (304)  
OR AMS 5524 (316)  
OR ASTM A240  
OR ASME SA240  
PER DART SPEC. M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

**REFERENCE ONLY**

**RELEASED**  
2011-09-21

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D4131</b>	SHEET 7 OF 10
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>MANIFOLD ASSEMBLY</b>	NTS
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**D4131-5 SIDE PLATE**

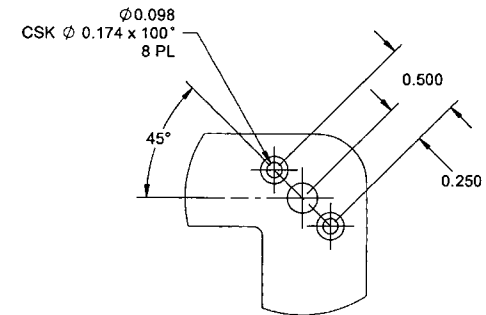
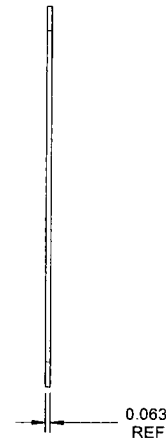
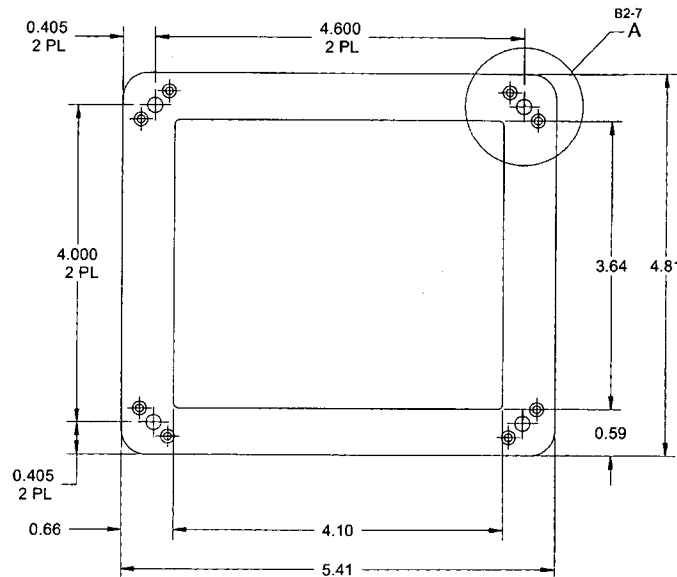
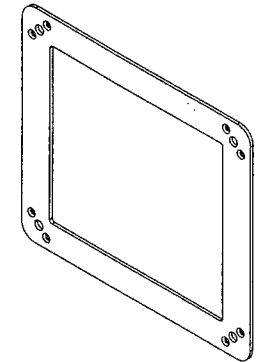
**RELEASED**  
2011-09-21  
AND

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET  
PER MIL-S-5059  
OR AMS 5513 (304)  
OR AMS 5524 (316)  
OR ASTM A240  
OR ASME SA240  
PER DART SPEC. M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D4131</b>	SHEET 8 OF 10
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>MANIFOLD ASSEMBLY</b>	NTS
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REFERENCE ONLY



DETAIL A D5-7  
TYPICAL

D4131-7 PLATE

NOTES:

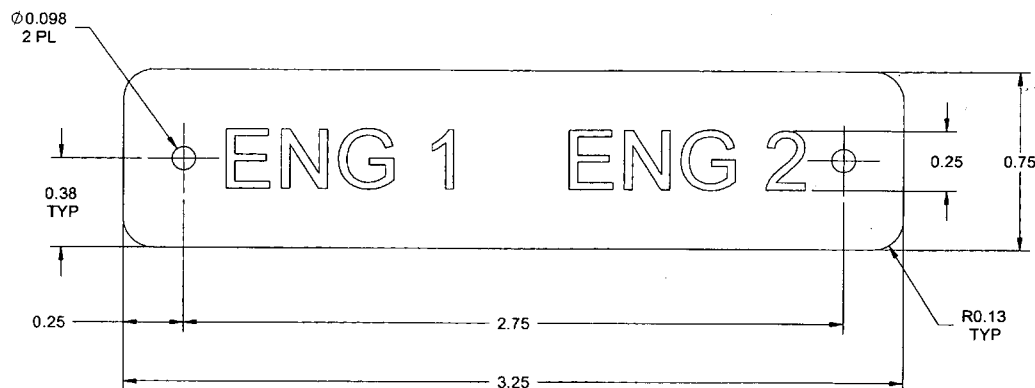
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS4027  
OR ASTM B209  
PER DART SPEC. M6061T6S0.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

RELEASED  
2011-09-21

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	140	D4131	SHEET 9 OF 10
APPROVED	140	TITLE	SCALE
DE APPR.	140	MANIFOLD ASSEMBLY	NTS
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ENG 1 ENG 2

REFERENCE ONLY







D4131-9 LABEL PLATE 

RELEASED  
2011-09-21

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.030 (22 GAUGE) SHEET  
PER MIL-S-5059  
OR AMS 5513 (304)  
OR AMS 5524 (316)  
OR ASTM A240  
OR ASME SA240  
PER DART SPEC. M304S22GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED		DRAWING NO. D4131	REV. B
MFG. APPR.		SHEET 10 OF 10	
APPROVED		TITLE	SCALE
DE APPR.		MANIFOLD ASSEMBLY	NTS
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